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tightening of the set-screw *I*), which hears against the work. The holes in the lugs of the castings are lined with steel hush-ings in artier to prevent the cast-iron holes from being worn out too soon by the constant pulling out and [Hitting in of the pin. This kind of leaf, when fitted in nicely, is rather expensive, but is used not only for binding purposes, but also for guiding purposes, making a convenient seat for the hushing\*. If leaves are fitted well in place, the bushings in the leaves will guide the cutting tools in a satisfactory manner.

Another method of clamping down the leaf is shown in Fig. 30, in which *A* is a thumb-screw, screwed directly into the wall *B* of the jig\* and holding the leaf (. down, as indicated. To swing the

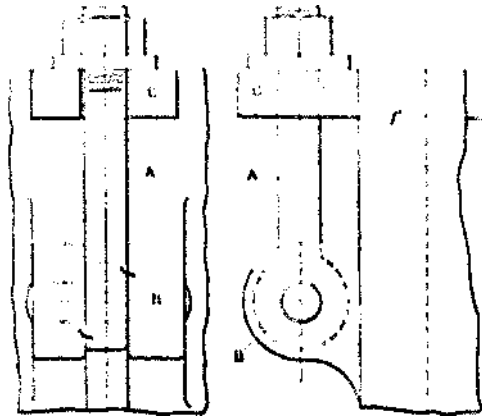


Fig. ji. Syt-boit Ittf Clumping Brill JJg

out, the ihumlvstrew 5\* turned b;uk alunt a quarter of the turn, HO that the head of the thumbscrew stands tn line with the riot m the leaf, thin slot bring nuule wide ;ui<i long enough to permit the leaf to clrai the head of tin\* thumb sirrw. Thin is a very rapid way of clamping, ami in frequently used. The lower side of the head of the screw will wear a time before the head finally comet\* in line with the slot when binding. It can then be fixetl for binding the leaf again when standing in a position where the head of the thumb MWW H at right angles to the dot, by turning off a portion of the head on the under side